

Work Order ID 113387

Wednesday, February 12, 2014 1:08:25 PM

113387

Page 1

Item ID: PB67-43001-111

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tube End Plate

Stop ***NS2***

Start Date: 2/11/2014 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/28/2014 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: ME

Date: 14-2-12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

16 0 Ac
14-02-18

60061.125"

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16 0 Ac
14-02-18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-88
14/2/18

16 0 Ac
14-02-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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1 13387

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/11/2014 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 2/28/2014 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

Quality Control

RM-02-1d

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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 113387

113387

Parent Item: PB67-43001-111

PR67-43001-111

Parent Item Name: Tube End Plate

Start Date: 2/11/2014

Required Date: 2/28/2014

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP rev A new issue 08.06.19 DD verified: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	170.5330	0.0156	1			

M6061T6S 125

6061-T6 .125 Sheet

Ac 14-02-18

Location

Loc Qty

Loc Code

MAT021

170.533

m127272

39.5

m127454

99.033

m127501

32

127454 → ①

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Ø1.50

0.125
REF

B67-43001-111 TUBE END PLATE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 32 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.02
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-111	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	TUBE END PLATE	NTS	
DATE	09.03.02	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

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Doc/Data										
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